

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009206**Date Inspected:** 19-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This QA Inspector observed the following work in progress: FCAW repair welding of OBG segment 1AAW to 1AW weld OBW1-001. ZPMC welder was identified as 220064. ZPMC QC is identified as Li Jia. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U2a-F.

FCAW repair welding of OBG segment 1AAW to 1AW weld OBW1A-003. ZPMC welder was identified as 048659. ZPMC QC is identified as Li Jia. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2-FCM-1.

Tower Outside Milling area:

Caltrans QA observed ABF QC perform Magnetic Particle Testing (MT) of West Tower Lift 1 Skin Plate A from 0 to the 9 meter mark. A total of 10 areas were marked by ABF QC.

Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing verification of OBG Deck Panel Tack welds for

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

DP3028-001-001 through 010 after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during this in process inspection.

Bay 11-

This QA Inspector observed the following work in progress: SMAW repair welding of East Tower Lift 3 diagonal plate weld ESTL3-4 G/K-077 and 078. ZPMC welder was identified as 041271. ZPMC QC is identified as Guo Peng. The welding appeared to be in conformance with welding procedure specifications, WPS-345-SMAW-1G (1F)-Repair and WPS-345-SMAW-1G (1F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QC and QA occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
